

Date: Monday, 22/09/2008 2:09:23 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	REPLACEMENT SHIM KIT
Job Number :	42197		
Estimate Number :	12557		
P.O. Number :		Part Number :	D412698021
This Issue :	22/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	IIN D412-698 REVD
First Issue :	11	Project Number :	N/A
Previous Run :	33509	Drawing Revision :	D
	Type :	Material :	
	MACHINED PARTS	Due Date :	20/10/2008
Written By :		Qty:	22
Checked & Approved By :	JUL 08-9-22	Um:	Each
Comment :	Est Rev:A 06.10.20 New issue ec Est Rev:B 08-01-28 change to rev D ECN 1104 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-021 CHG001

N/A paperwork to see attached
 email from 1994

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D32381	Plate
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 66.0000 Each(s)

Plate

Batch:

B33511 x 11 B42225 x 55

JS 08/10/21 (22)

4.0	D32383	Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Plate

Batch:

B33515 x 17 B42229 x 5

JS 08/10/21 (22)

5.0	D32385	Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 44.0000 Each(s)

Plate

Batch:

B33716 x 19 B42272 x 25

JS 08/10/21 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 2:09:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT SHIM KIT

Job Number: 42197

Part Number: D412698021

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D323811

Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 132.0000 Each(s)

Plate

Batch: 33517 7X B 42226 10X

7.0 D323813

Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 44.0000 Each(s)

Plate

Batch: 40298 3X 40227 41X

8.0 D323815

Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 88.0000 Each(s)

Plate

Batch: B42228

9.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-021

Location:

PPP Rev: PROET

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U081029

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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NO. 42197

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

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Revision: E
 Date: 08.05.01

L Lacelle

From: Peggy McDonald [peggy@darths.com]
Sent: October 28, 2008 1:23 PM
To: 'L Lacelle'
Subject: RE: amod order

No need for paper work.
Thanks for saving a tree.

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: October 28, 2008 1:21 PM
To: 'Peggy McDonald'
Subject: amod order

Hiya Peggy,

We have the shim kits ready to package and it, of course, calls for paperwork.
I was wondering if they absolutely need paperwork for these, since the roller kits already come with the same paperwork? It's 64 pages, and I feel like I'm killing trees for nothing...let me know what your preference is.

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

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28/10/2008